

BSS



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBEM632V3013101-5
Job Sheet 182039



JS A39
B14

0/S

Part No: RBEM632V3013101-5 Job Qty: 6 ea

Part Name: Rod



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 8/16/18

Job Tracking No:

Due Date: 8/20/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM632V3013101 REV 1 SHEET 4

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		8/20/18	0.00	0.00	Start Up Machining-2		
110	Bandsaw	6 pcs		8/20/18	0.00	0.30	Bandsaw1		
120	Lathe Conv	6 pcs		8/20/18	0.00	0.68	Lathe Conv-1		
130	QC	6 pcs		8/20/18	0.00	0.00	QC2 Machining-4		
140	Mill Conv	6 pcs		8/20/18	0.00	3.00	Mill Conv 2		
150	QC	6 pcs		8/20/18	0.00	0.00	QC2 Machining-4		
160	QC	6 pcs		8/20/18	0.00	0.00	QC8 Machining-4		
180	Outsource	6 pcs		8/20/18			GRO002-VC	10	
190	Packaging	6 pcs		8/20/18	0.00	0.00	Packaging2		
200	QC	6 pcs		8/20/18	0.00	0.00	QC6		
210	Powdercoat	6 pcs		8/20/18	0.00	1.20	Powdercoat13		
220	QC	6 pcs		8/20/18	0.00	0.00	QC3		
230	Packaging	6 pcs		8/20/18	0.00	0.00	Packaging3-1		
240	QC21-SA	6 Ea		8/20/18	0.00	0.00	QC21		

Part Op 110 - Cut blanks to 16.9".

Descriptions: 120 - Machine as per DWG.

140 - Machine as per DWG.

180 - Issue P/O to Groupe Altech : P/O 040850 - Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required

210 - Powder coat YELLOW; FED # 13538 - No Powder coat at this location note 2 as per DWG. START TIME: 8:30

OVEN TEMPERATURE: 520° FINISH TIME: 9:00.

M138677.

18/8/18
15-SEP-05 2018
SEP 1 2018
9-89
21 SEP 11 2018
9-89

GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018R1.00	1018-1025 Round Bar 1.00	8.4360 ft (1.406 ea)	90-Start up Operation	5042212

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M1018R1.00	8	35	0

Part Specifications

Specifications could not be found.



Container No: S105753



Part: RBEM632V3013101-5

Job No: 182039

Serial No/Batch: S105753

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/28/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

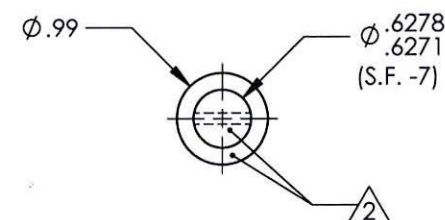
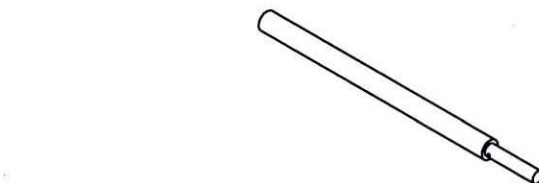
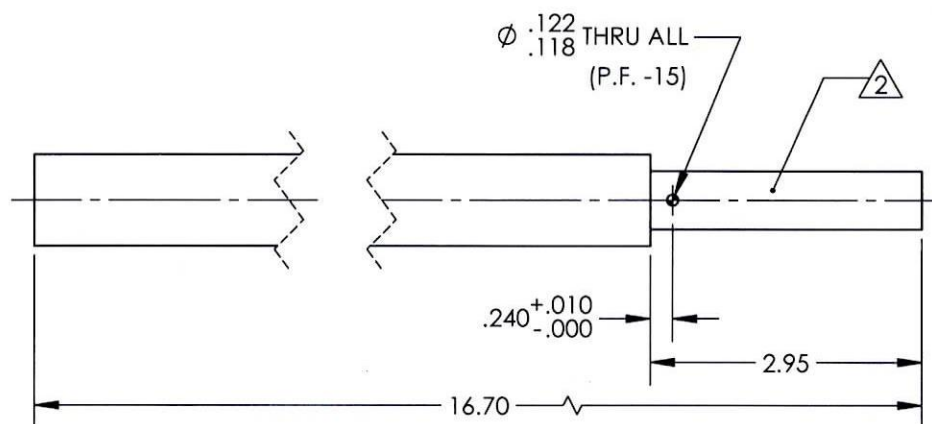
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



Before Plating

0.6272
0.6265

NOTES:

- DUAL FINISH:
1ST: ZINC PLATE, ASTM B633 TYPE I SC2 (0.0003)
2ND: POWDER COAT YELLOW, FED #13538.

2 NO POWDER COAT THIS SURFACE.



TITLE
SERVO-CONTROL FITTINGS NUT GUIDE

DWG NO. RBEM632V3013101-5 REV 1

MAT'L 1018/1020 CR		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE NOTE 1		.XXX ± .005	FRACTIONS ± 1/16
SPEC		.XX ± .01	ANGLES ± .5°
DRAWN BY: DUERFELDT		.X ± .1	SURFACES = 125✓
CHECKED: CLOUGH		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 1:2		3. INTERPRET DIM AND TOL PER	
DATE 6/14/2016		ASME Y14.5M-2009	
SHEET 4 OF 10		USED ON MODEL	
		H175	

(-5)

ROD

300-430/630-830



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040850**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040850
PO Date: 8/27/18
Due Date: 8/31/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181821	RBT102098-3	Plate -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	8/31/18	.8 pcs	0 pcs	8 pcs	\$15.00/pcs	\$120.00
2	178199	RBEM262V3000101-19	Angle Bracket -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Material type; 1018 -Certificate of Conformity is required	Firmed	-	8/31/18	6 pcs	0 pcs	6 pcs	\$15.00/pcs	\$90.00

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	180095	RBE350A93-3500-00-1	Body -Issue P/O to Groupe Altech: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant as per Dwg RBE350A93-3500-00-1 Rev. 3A -Certificate of Conformity is required	Firmed	-	8/31/18	22 pcs	0 pcs	22 pcs	\$5.454545/pcs	\$120.00
							22 X	AUG 31 2018			
4	178985	RBE350A94-3700-A-03	Top -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/31/18	41 pcs	0 pcs	41 pcs	\$1.89/pcs	\$77.49
							41 X	SEP 04 2018			
5	181158	RBE350A94-3700-A-03	Top -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/31/18	20 pcs	0 pcs	20 pcs	\$1.89/pcs	\$37.80
							20 X	SEP 04 2018			
6	181469	C2-12-3	Lock -Issue P/O to Groupe Altech: P/O -Nickel plate, QQ-N-290, Class 2, Grade E or F ****verify plating thickness, grade could change**** NICKEL PLATE TO .0004-.0006 BAKE AFTER PLATE - Certificate of Conformity is required	Firmed	-	8/31/18	20 pcs	0 pcs	20 pcs	\$12.00/pcs	\$240.00
							20 X	SEP 04 2018			



Certificat de Conformité / Certificate of Compliance

(012221-3)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

012221 - 3

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
05-Sep-2018		Aman		040850					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir/ Back Order
9	RBEM632V3013101-5 Rev. ✓	ROD 01-ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] SPÉC: ASTM B633 TYPE 1 SC2 ***	ZINC CH	6	6	0	0	0	0

 DAS
 38
 9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	178986	RBE350A94-3700-A-01	Tube -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/31/18	30 pcs	0 pcs	30 pcs	\$3.85/pcs	\$115.50
8	181869	RBE350A94-3700-B-01	Tube -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/31/18	8 pcs	0 pcs	8 pcs	\$3.55/pcs	\$28.40
9	182039	RBE350A94-3700-A-05	Rod -Issue P/O to Groupe Altech : P/O -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed	-	8/31/18	6 pcs	0 pcs	6 pcs	\$15.00/pcs	\$90.00
10	180175	RBE350A94-3700-A-05	Foot -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/31/18	40 pcs	0 pcs	40 pcs	\$2.80/pcs	\$112.00
Grand Total:											\$1,031.19

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.